

17/9

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:55:59 AM  
 User: Chantal Lavoie

## Process Sheet

|   |                                      |
|---|--------------------------------------|
| Customer :  | Drawing Name : STIFFNER              |
| Job Number : 34541  |                                      |
| Estimate Number : 12958                                     |                                      |
| P.O. Number : N/A   | Part Number : D36394                 |
| This Issue : 9/11/2007 S.O. No. : N/A                       | Drawing Number : D3639 UNDER REVIEW  |
| Prsht Rev. : NC   | Project Number : N/A                 |
| First Issue : N/A Type : SMALL /MED FAB                     | Drawing Revision : U/R               |
| Previous Run : N/A  | Material : N/A                       |
| Written By : _____  | Due Date : 9/18/2007 Qty: 5 Um: Each |
| Checked & Approved By : _____                               |                                      |
| Comment : Est Rev: A New Issue 07-07-20 JLM Verified By: EC |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.4491 sf(s)/Unit Total: 4.4909 sf(s)

2024-T3 .050 sheet

Batch: M ~~105646~~ 1807-09-19

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3639

Dwg Rev: PRE L 1807-09-19

Prog Rev: PRE L

2-Deburr if necessary

P10 →  
 5  
 10

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1807-09-19

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 12/09/19

X10

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3639

N/A 9/11/07-09-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/10/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |                                |  |                |                           |                       |                          |
|----------|------|---|--------------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action<br>Section B |  |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |   | Initial<br>Chief Eng           | Action Description<br>Chief Eng            | Sign &<br>Date |                           |                       |                          |
| 07/09/12 | #20  | 5 Parts Scrap.<br>wrong Program was used<br>(Preliminary not the new DFY)<br>causing the location of the<br>0.625" and 0.191 holes<br>to be off by 0.100" |                                | Scrap and Destroy<br>and Replace all parts |                | En<br>07/09/12            |                       | En<br>07/09/12           |
|          |      | R.C. wrong Program was<br>on the network and Hummer<br>operator error. (water jet)  |                                | Remove wrong Program<br>from the network   |                | En<br>07/09/12            |                       | En<br>07/09/12           |
|          |      |   |                                |  |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:00 AM  
User: Chantal Lavoie

## Process Sheet

Customer:

Drawing Name: STIFFNER

Job Number: 34541

Part Number: D36394

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

SB 07/10/20

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 02/07/20 (10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/09/20

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 02/02/21 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

7/10/15 50

(10)

LE 07.10.14  
ENGINEERING  
APPROVAL

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)  
07/10/22

Job Completion



u 07.10.16

POSITIVE RECALL

EFFECTIVE 07.09.11

AUTH

RELEASED

DATE

07.10.14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                        |           |              |         |
|------------------------|-----------|--------------|---------|
| DART AEROSPACE LTD     |           | Work Order:  | 34541   |
| Description: STIFFENER |           | Part Number: | D3689-4 |
| Inspection Dwg:        | Rev: PREL | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .098            | + .004 - .001 | .100             | X      |        |                      |          |
| Ø .191            | + .005 - .001 | .194             | X      |        |                      |          |
| Ø .625            | + .008 - .001 | .627             | X      |        |                      |          |
| .45               | +/- .030      | .45              | X      |        |                      |          |
| 1.350             | +/- .010      | 1.350            | X      |        |                      |          |
| 2.25              | +/- .030      | 2.25             | X      |        |                      |          |
| 3.15              | +/- .030      | 3.15             | X      |        |                      |          |
| 4.05              | +/- .030      | 4.05             | X      |        |                      |          |
| 4.95              | +/- .030      | 4.94             | X      |        |                      |          |
| 5.85              | +/- .030      | 5.85             | X      |        |                      |          |
| 6.75              | +/- .030      | 6.75             | /      |        |                      |          |
| 7.65              | +/- .030      | 7.65             | /      |        |                      |          |
| 8.55              | +/- .030      | 8.55             | /      |        |                      |          |
| 9.350             | +/- .010      | 9.350            | /      |        |                      |          |
| 9.45              | +/- .030      | 9.45             | /      |        |                      |          |
| 10.350            | +/- .010      | 10.350           | /      |        |                      |          |
| 11.25             | +/- .030      | 11.25            | /      |        |                      |          |
| 12.15             | +/- .030      | 12.15            | X      |        |                      |          |
| 12.85             | +/- .030      | BEND LINE        |        |        |                      |          |
| 13.86             | +/- .030      | 13.86            | X      |        |                      |          |
| 13.96             | +/- .030      | 13.96            | X      |        |                      |          |
| 14.65             | +/- .010      |                  |        |        |                      |          |
| 15.00             | +/- .030      |                  |        |        |                      |          |
| 16.00             | +/- .030      |                  |        |        |                      |          |

continued on next Page

|                 |                         |                                 |
|-----------------|-------------------------|---------------------------------|
| Measured by: HB | Audited by: [Signature] | Prototype Approval: [Signature] |
| Date: 07-09-19  | Date: 07/09/19          | Date: 07.09.19                  |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |

